

Date: Thursday, 22/11/2007 12:55:58 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : REWORK
Job Number : 35961	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D2807041
This Issue : 22/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : ECN 1019
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : <i>N/A</i>
Previous Run : 00015	Material : <i>N/A</i>
Written By : _____	Due Date : 29/11/2007 Qty: 5 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D2807 B *32774*

SB 07/11/22 (5)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 ADD D3671-1 PLACARD B *35613*
 TO D2807 (BECOMES D2807-041)
 PER DRWG D2807-041

mf 07-11-22

3.0

D2807

Gas Spring (Support Prop)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Gas Spring (Support Prop)

B 32774

SB 07/11/22 (5)

4.0

D36711

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 PLACARD

B 35613

SB 07/11/22 (5)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/11/23 (5)

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Drawing Name: REWORK

Job Number: 35961

Part Number: D2807041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
RESTOCK USING NEW B/N

07/14/23

(5)

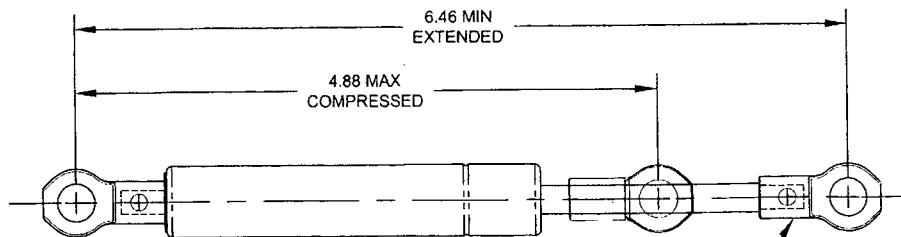
5748

Job Completion



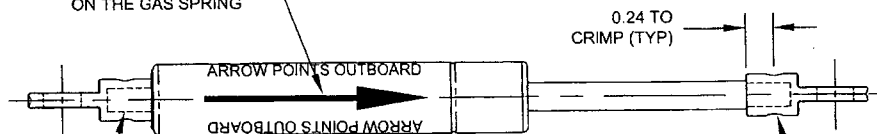
QCAL Final W/O inspection 07/11/06

W 07/11/06



D2807-3 LUG
(2 PLACES)

AFFIX D3671-1 PLACARD (1)
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
UP TO 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

CRIMP 0.015-0.025\"/>



D2807-1 GAS SPRING

NOTES:

- 1) MATERIAL: NONE - SEE NOTE #8
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.147 lbs
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE,
115N LOAD)

D2807-041 GAS SPRING ASSEMBLY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.179 lbs

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-1	GAS SPRING
2	D2807-3	LUG
1	D3671-1	PLACARD

RELEASED
07.11.08

Handwritten signature/initials

D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	07.09.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2807
REV. D
SHEET 1 OF 2
TITLE GAS SPRING
SCALE 1:1

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